

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010620**Date Inspected:** 16-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Gong Liang Zhu, Chen Ying Xin.			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower Components		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10, South Tower, Interior Splice Plate.

FCAW welding of weld joint SSD1-SPSA4-16-1A & SSD1-SPSA4-26-2A & SSD1-SPSA4-24-2B; located on Bay 10, South tower. Welders are identified as 040261, 048627, 040533; ZPMC Quality Control Inspector (QC) is identified as Gong Liang Zhu. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-B-T-2232-B-U5-F, 2) WPS-B-T-2231-TC-U5-F.

Bay 10, North Tower, Corner Splice.

SMAW Repair welding of weld joint ND1-A5002-27-1B(CWR # T-CWR455); located on Bay 10, North tower. Welders are identified as 052493; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-485-SMAW-2G(2F)-FCM-REPAIR.

This QA Inspector carried out NDE on following

Bay 11, Tower Skirt Plates.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT

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## WELDING INSPECTION REPORT

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report(TL-6028) for this date. The members are identified as

1) ED1-A149A/C-4 TO 207.

2) WD1-A504A/C-1 TO 184, 302 TO 322.

Bay 11, West Tower, Lift 2 & 3, Corner Splice Plate of BC Corner.

This QA inspector performs Random Visual Testing (VT) after Milling; of area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as

1) WSD1-SPSA3-55-1, 2 (A/B).

2) ESD1-SPSA3-55-1, 2 (A/B).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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